

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014941**Date Inspected:** 15-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Gao Zhi Chun		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005988

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Tower Component. The identified component designations reviewed are as follows:

NORTH TOWER LIFT-1, GAP BETWEEN BASE PLATE AND BEARING PLATE

SKIN'B' EXTERNAL – 4 LOCATIONS

SKIN'D' EXTERNAL – 8 LOCATIONS

SKIN'D' INTERNAL – 1 LOCATION

SKIN'E' EXTERNAL – 3 LOCATIONS

SKIN'E' INTERNAL – 1 LOCATION

BAY#10

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 4B located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 6. Welder is identified as 050266. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 2B located on Lift-5 Splice Plate Stiffener NSD1 – SPSA5 – 16. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 41A located on Lift – 5 north tower A/E corner to Grillage plate NSD1 – TL5 – 4B/F. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – B – U3b.

Weld joint # 2B located on Lift-5 Splice Plate Stiffener NSD1 – SPSA5 – 6. Welder is identified as 044511. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1. (See attached photo)

Weld joint # 24B located on Lift – 5 north tower A/E corner to Grillage plate NSD1 – TL5 – 4B/F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – B – U3b.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 1A located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 20. Welder is identified as 040611. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 1B located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 2. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 3B located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 7. Welder is identified as 046709. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

MEASUREMENTS ON TOWER STRUTS

This QA Inspector carried out the measurements on Tower Struts to check the length, flange to flange distance, stiffener to stiffener distance, bolt hole to edge of the strut distance and 1:1 fillet weld termination & 10mm minimum clearance from fillet to CJP at stiffeners. Measurements were recorded on the data sheet and submitted to the assigned task leader. The identified component designations reviewed are as follows

TOWER STRUTS

WELDING INSPECTION REPORT

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1. ED1 – A6001 – 8
2. ED1 – A6003 – 2
3. ED1 – A6003 – 6
4. ND1 – A6002 – 1
5. SD1 – A6002 – 17
6. ND1 – A6002 – 12
7. ND1 – A6002 – 7
8. ND1 – A6002 – 9
9. ND1 – A6002 – 14
10. ND1 – A6002 – 13
11. ND1 – A6002 – 2
12. ND1 – A6002 – 11

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
